

Date: Wednesday, 3/15/2006 3:42:39 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 26252					
Estimate Number	: 10334					
P.O. Number	: N/A			Part Number	: D2804042	
This Issue	: 3/15/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2804 REV B	
First Issue	: N/A		Type	: R & D SM/MED FAB		
Previous Run	: 25920			Project Number	: N/A	
Written By	: See comment below			Drawing Revision	: B	
Checked & Approved By	: 06.03.16 W			Material	: N/A	
Comment	: Est F 05.03.30 MS21043-3 was MS21042L3			Due Date	: 3/24/2006	
				Qty:	10	Um: Each
				KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D28042	STA 155 Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STA 155 Bracket	
		Pick: Qty Part Number      Description      Batch	
		1      D2804-2      Bracket <u>B27 303</u>	
2.0	D28052	Stop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Stop	
		Pick: Qty Part Number      Description      Batch	
		1      D2805-2      Stop <u>340 06:06:12</u> <u>10</u>	
		<u>340 06:06:12</u> <u>R27305 (4)</u>	
3.0	D2809	Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing	
		Pick: Qty      Part Number      Description      Batch	
		1      D2809      Bushing <u>B27 306</u>	
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-2 into arm as per Dwg D2804	
		<u>CAD 06:06:19</u>	
		<u>S40 06:06:19</u>	
		(10)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: BRACKET ASSEMBLY

Job Number: 26252

Part Number: D2804042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/06/19

10

6.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/19 10

10

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 06-06-20

10

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press Fit D2809 as per Dwg D2804

FF 06-06-20

10

9.0 AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	m 101189

10.0 MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	m 19099

11.0 NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch	4 NAS1515H3	Washer m 19 b33
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A/R

LPS-3

Corrosion Spray

m 17395

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/06/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 26252

Part Number: D2804042

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

H.M 06-6-20

(10)

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 06/06/20

10

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 159

DOCUMENT CONTROL

RE 06/06/20 (10)

(18)

15.0 DC



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/21

(18)

Job Completion



U 06.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

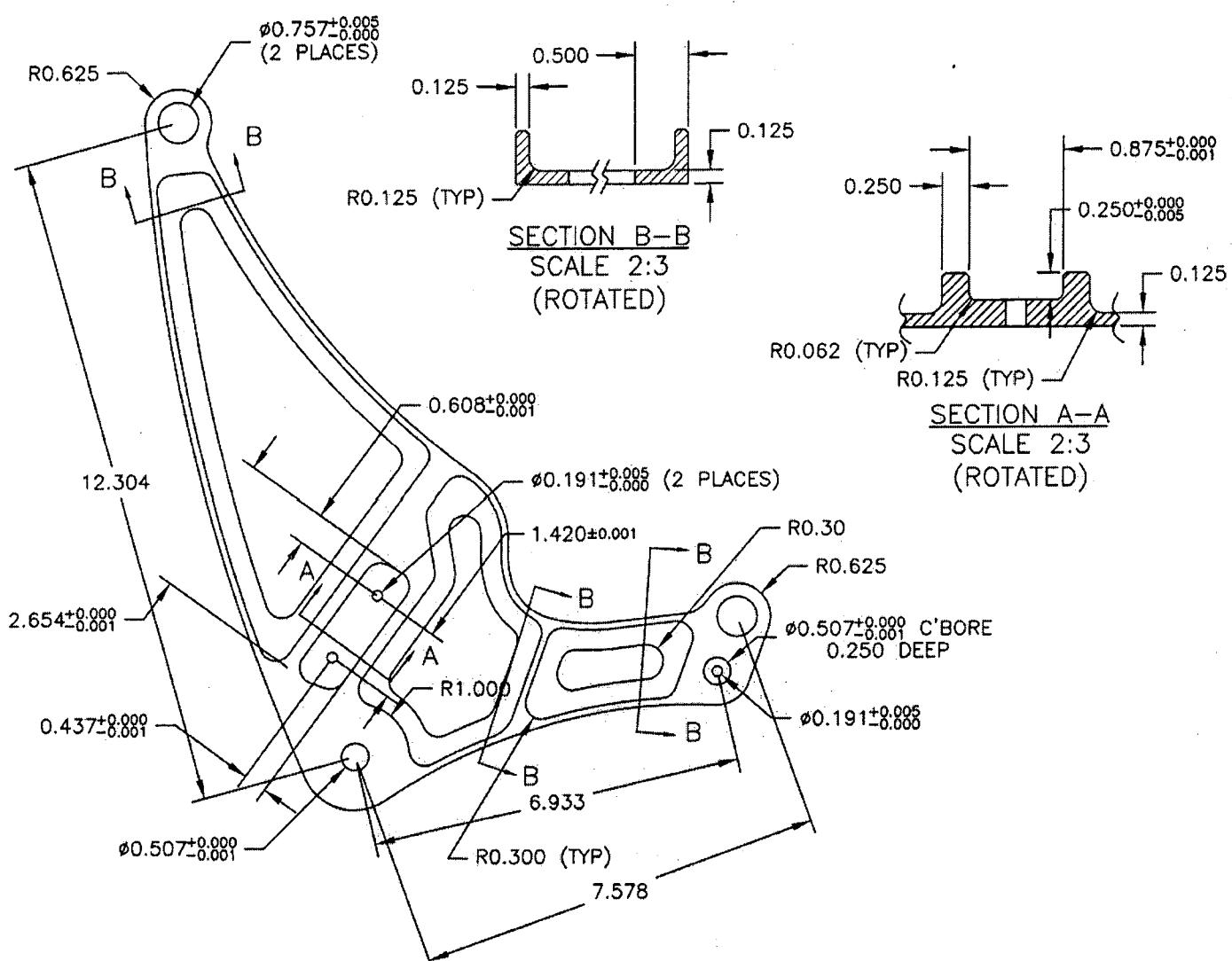
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. B	SHEET 1 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3	
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS. & -043/-044		

RELEASED

05.03.11 -



SHOP COPY  
RETURN TO  
ENGINEERING

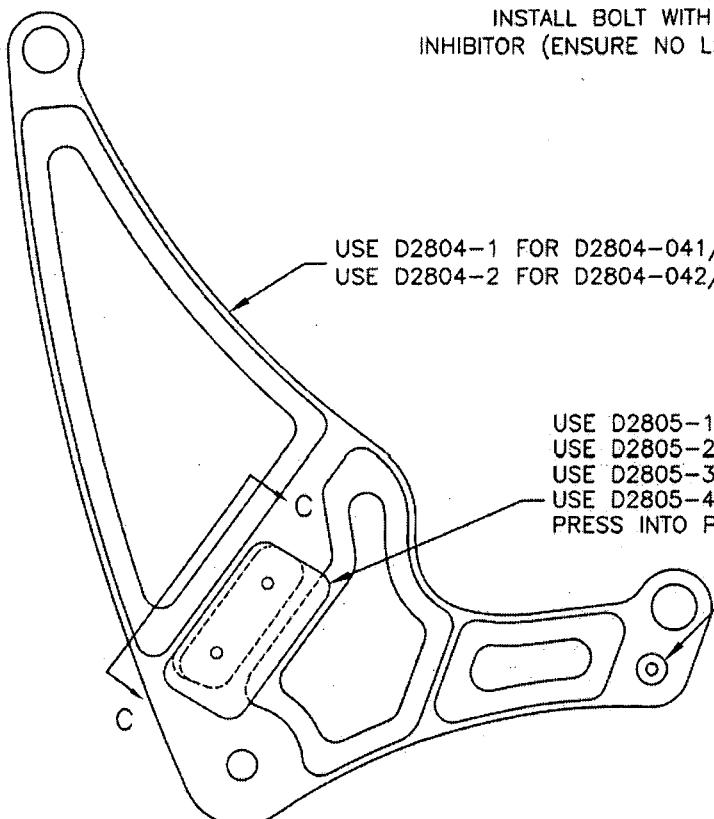
D2804-1 BRACKET (SHOWN), D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT" S  
2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 T  
3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

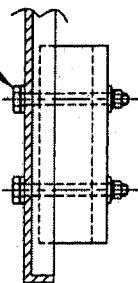
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
THICK WORK ORDER  
NO. 26252

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3



AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21043-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)



SECTION C-C  
SCALE 1:3  
(ROTATED)

USE D2805-1 FOR D2804-041  
USE D2805-2 FOR D2804-042  
USE D2805-3 FOR D2804-043  
USE D2805-4 FOR D2804-044  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO  
POWDER COAT

SHOP COPY  
RETURN TO

RELEASED  
05-03-11  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 26252

D2804-041/-043 BRACKET ASS'Y (SHOWN)  
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

- 6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)  
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3